

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-028080**Date Inspected:** 30-Jul-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1930**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** jobsite**CWI Name:** Steve Jensen/William Sherwood**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

At the start of the shift this Quality Assurance Inspector (QA) traveled to the SAS project site and observed the work and the inspection performed by American Bridge/Fluor Enterprises (AB/F) welding and Quality Control (QC) personnel. The observations and inspections were performed as noted below:

13W/14W Drop-In

This QAI observed the fitting of plate FS-13-WJ to the corresponding stiffener. After the initial fit-up an 11mm gap existed between plate FS-13-WJ and the corresponding stiffener. This QAI reported the non-compliance to American Bridge Quality Control Inspector Steve Jensen, and the issue was resolved promptly. The gap between the plates just prior to welding was 2mm. Strong backs were used to keep the plates in position until enough weld had been deposited.

This QAI observed Welder Xiao Juan Wan (ID#9677) using a rosebud torch to preheat Stiffeners 12W/13W LS-7, and LS-8 to a QC recorded, QA verified temperature of 250F. Preheat temperature was measured using a Tempil Stick. This QAI noted QC Tony Sherwood recording preheat temperature whenever there was a stop in work.

After fitting operations and the proper preheat temperature was achieved, Xiao Hua Luo (ID#1291) began welding the plates together utilizing the Shield Metal Arc Welding Process to the parameters in the Approved Welding Procedure Specification for the 3G, and 4G position.

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This QAI witnessed induction heating blankets positioned above weld 13W-W122.2 and a preheat temperature of 325F maintained for most of the afternoon, but no work was performed.

Rick Clayborn began the process of grinding the B side of weld W13-W2.1 flush, in preparation for inspection and testing. This QAI performed a visual inspection and found that the ground portion of the weld met the ground flush requirements of The American Welding Society AWS D1.5-02. Grinding is not complete on the B side of weld.



Summary of Conversations:

There were general conversations with Quality Control Inspector Steve Jensen, at the start of the shift regarding the location of welding, inspection personnel scheduled for this shift. All observations were relayed to Bill Levell.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510 385 5910, who represents the Office of Structural Materials for your project.

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Inspected By: Daggett, Matt

Quality Assurance Inspector

Reviewed By: Levell, Bill

QA Reviewer